

Work Order ID 128618

128618

Page 1

Tuesday, January 20, 2015 8:06:12 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 1501-20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-042	G
D3492	C

100	Document Control	0.00
-----	------------------	------

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

record fwd angle:

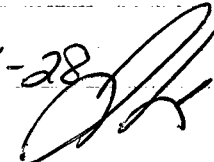
89.4°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
27
8-89

DAS
46
9-89

MAR 16 2015

15-1-28 

Work Order ID 128618

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***Start Date: 1/20/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Burr Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

DGC 15-1-28

DGC 15-1-28

15-1-28

BE 15-1-29

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Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Description	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	------------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M130812

9- Grind welds flush as per Dwg D2750

7 8E15-1-29

120	QC10- Inspect visual per QSI004- ground welds	0.00
-----	---	------

120

QC

Quality Control

Memo	0.00
------	------

FEB 02 2015

DAS
24
9-89

130	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

130

QC

Quality Control

Memo	0.00
------	------

DAS
03
9-89

15-2-2

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float
CompatibleStart Date: 1/20/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00 ***1***

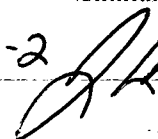
Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

15-2-2 15-2-2 

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Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop *NS2*

Start Date: 1/20/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

12- Deburr holes, ensure tube is free of all scratches before sending to paint.

> DGL 15-2-12

170 QC10- Inspect visual per QSI004- ground welds 0.00

170

QC Memo 0.00

Quality Control

① 150220

DAS
9
9-88

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC Memo 0.00

Quality Control

VERIFY C'BOARD IS GOOD

① 150220

DAS
9
9-88

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID
190

Operation
Description
Pressure Wash per QSI005 4.3

Set Up/
Buss Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1

9

15-2-20

DG

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: 130992

2- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 131599

1

DAS
41
9-89

15-2-23

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

IRH 4 15/03/03

DAS
15
9-89

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NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur.Float Compatible

Start Date: 1/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

NR1

QC: Date: SPC (Y/N): Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo								
	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>11131574</u>								
	EXP DATE: <u>15/16</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11131344</u> <u>13TUS98344</u> <u>1125792</u> <u>exp:15/16</u>								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>11122906</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

MAR 05 2015

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop

NS2

Start Date: 1/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								

DAS
27
8-89
MAR 12 2015

DAS
46
9-89

1x

DAS
46
9-89

MAR 13 2015

1x

DAS
46
9-89

FG OFB

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Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID
280Operation
Description
QC21- Final Inspection - Work Order ReleaseSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp***280***

QC

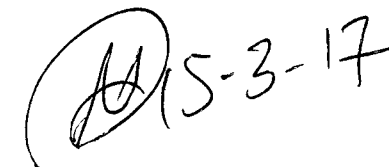
Memo

0.00

Quality Control

MJS

15-03-18



Picklist Print

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Page 1

Work Order ID: 128618

128618

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT-RH

Manufactured

No

110

Each

1.0000

1

1

D2600-3-BENT-RH

Extrusion Bent RH

**

128628 x1

DGC 15-1-28

Location

Loc Qty

Loc Code

LG002

1

125888

1

D2744

Manufactured

No

110

Each

21.0000

1

1

D2744

Cap

**

BK5-1-29

Location

Loc Qty

Loc Code

LG001

21

125894

21

D2739

Manufactured

No

160

Each

3.0000

1

1

D2739

350 I Beam

**

DGC 15-2-2

Location

Loc Qty

Loc Code

LG003

3

125858

3

Picklist Print

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Work Order ID: 128618

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

D2743

Manufactured No

160 Each

Start Qty: 1.00
19.0000 8 8

Required Qty: 1.00

D2743

Crossbolt Spacer

**

BE15-02-11
B128943 xB

Location

Loc Qty

Loc Code

LG001

19

125893

8

127636

11

D3490-3

Manufactured No

160 Each

31.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE15-02-05

Location

Loc Qty

Loc Code

LG001

31

125903

31

D3490-1

Manufactured No

160 Each

49.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE15-02-05

Location

Loc Qty

Loc Code

LG001

49

125902

49

D3631-1

Manufactured No

230 Each

74.0000 8 8

D3631-1

Washer

**

1315103101

Location

Loc Qty

Loc Code

FP001

74

125912

74

B128910

x8

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

D3791-1 Manufactured No 230 Each 46.0000 1 1
D3791-1 ** 15/03/04
Wearpad

Location	Loc Qty	Loc Code
FP002	46	
125913	22	
126317	24	

D3793-3 Manufactured No 230 Each 24.0000 1 1
D3793-3 ** 15/03/04
Wearplate Aft

Location	Loc Qty	Loc Code
FP002	24	
125915	24	B128236

MS21043-6 Purchased No 230 Each 158.0000 4 4
MS21043-6 ** 15/03/04
NUT

Location	Loc Qty	Loc Code
FG	20	
103693	20	11131618
FP001	138	
m130325	2	
m130726	136	

D3794-1 Manufactured No 230 Each 20.0000 1 1
D3794-1 ** 15/03/04
Gasket Fwd

Location	Loc Qty	Loc Code
FP001	20	
125916	20	B128238

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

NAS1611-010

Purchased

No

230

Each

52.0000

8

8

Start Qty: 1.00

Required Qty: 1.00

**

NAS1611-010

O-RING

HL 1/20/15

Location

Loc Qty

Loc Code

FP001

52?

11130770

m130797

52.

11131329

1

1

**

D2741

Manufactured

No

250

Each

41.0000

1

1

D2741

Replacement Blade

DAS
46
9-89

28088

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

31

125892

31

**

NAS1515H3L

Purchased

No

230

Each

627.0000

4

4

***NAS1515H3I ***

Washer

DAS
27
MAR 12 2015

HL 1/20/15

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

59

m127831

59

ST266

528

m127831

48

m130726

480

yJ

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Work Order ID: 128618

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

NAS1611-013

Purchased

No

230

Each

Start Qty: 1.00
830.0000 8 8

Required Qty: 1.00

NAS1611-013

O-RING

**

151031001

Location

Loc Qty

Loc Code

FP001

830

m130758

830

AN3C6A

Purchased

No

230

Each

544.0000 4 4

AN3C6A

Bolt

**

151031001

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

FP001

58

m128769

58

ST338a

437

m128769

437

NAS1149C0832R

Purchased

No

230

Each

173.0000 1 1

NAS1149C0832R

Washer

**

151031001

Location

Loc Qty

Loc Code

FP001

29

m114915

29

ST271

144

m125807

144

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

D3536-25

Manufactured No

230

Each

23.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D3536-25

Gasket Center

**

15/03/06

Location

Loc Qty

Loc Code

FG

6

87053

2

B130190

95328

4

FP001

17

125909

17

D3794-3

Manufactured No

230

Each

59.0000

1

1

D3794-3

Gasket Aft

**

15/03/06

Location

Loc Qty

Loc Code

FP001

59

125917

19

B128239

127383

39

92658

1

AN3C5A

Purchased No

230

Each

549.0000

34

34

AN3C5A

Bolt

**

15/03/06

Location

Loc Qty

Loc Code

FG

5

122800

5

11131420

ST338a

544

M130770

528

M130851

16

234

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

D3537-1

Manufactured No

230

Each

67.0000

3

3

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Wearpad

**

15103104

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

49

126306

4

126307

45

B127087

x3

D3535-25

Manufactured No

230

Each

36.0000

1

1

D3535-25

Wearplate Center

**

15103104

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

16

128090

16

FP007

18

127851

18

x1

D3492-3

Manufactured No

230

Each

74.0000

8

8

D3492-3

Plug

**

15103104

Location

Loc Qty

Loc Code

FP001

74

125905

74

B128914

x2

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

NAS1149C0332R Purchased No 230 Each 3,471.000 38 38

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R
WASHER

**

15/03/04

Location	Loc Qty	Loc Code
FP001	2445	
m130325	2445	1131340
GA	26	
125654	26	
ST271	1000	
m130466	1000	

x38

D3488-042 Manufactured No 230 Each 18.0000 1 1

D3488-042
Blade Fitting RH

**

15/03/04

Location	Loc Qty	Loc Code
FP001	18	
125899	9	13128804
125900	9	

x1

ALS4-1032-225 AELS8-1032-225 Purchased No 230 Each 892.0000 38 38

ALS4-1032-225
Rivnut

OR ALS4-1032-225

**

15/03/04

Location	Loc Qty	Loc Code
FG	120	
M127028	120	1131654
st549	772	
M131067	772	

x38

D3492-1 Manufactured No 230 Each 53.0000 8 8

D3492-1
Plug

**

15/03/04

Location	Loc Qty	Loc Code
FP001	53	
125904	53	B128509

x8

Tuesday, January 20, 2015 8:06:19 AM

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Picklist Print

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Page 9

Work Order ID: 128618

128618

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

D3793-1 Manufactured No 230 Each 27.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Wearplate Fwd

**

38 15/03/01

Location Loc Qty Loc Code

FP002 27

125914 27

AN8C35A Purchased No 230 Each 10.0000 1 1

AN8C35A

Bolt

**

38 15/03/01

Location Loc Qty Loc Code

FG 5

121275 5

FP001 5

m130784 5

MS21083C8 Purchased No 230 Each 97.0000 1 1

MS21083C8

Nut

**

38 15/03/01

Location Loc Qty Loc Code

ST300 97

m131049 97

D2745 Manufactured No 230 Each 140.0000 8 8

D2745

Bushing

**

38 15/03/01

Location Loc Qty Loc Code

ST010 140

125895 4

127585 136

B128480

B128089

X6

V7

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Page 9

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Page 10

Work Order ID: 128618

128618

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

AN6C44A

Purchased

No

230

Each

90.0000

4

4

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Bolt

**

15103160

Location

Loc Qty

Loc Code

FG

2

103964

2

11131546

ycl

FP001

12

m130863

4

m130982

8

ST286A

13

m130863

13

ST332

11

m130863

11

ST333

52

m131151

52

D3532-1

Manufactured

No

250

Each

32.0000

2

2

D3532-1

DAS

46

Spacer

9-89

**

DAS

27

9-89

MAR 12 2015

Location

Loc Qty

Loc Code

ST048

32

125907

32

B128091

2

MS21083C8

Purchased

No

250

Each

97.0000

2

2

MS21083C8

DAS

46

Nut

9-89

**

DAS

27

9-89

MAR 12 2015

Location

Loc Qty

Loc Code

ST300

97

m131049

97

M1316B

2

Picklist Print

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Page 11

Work Order ID: 128618

128618

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/20/2015

Required Date: 1/20/2015

NAS1149D0863J

Purchased

No

250

Each

Start Qty: 1.00
756.0000 2 2

Required Qty: 1.00

NAS1149D0863J

DAS

Washer

46
9-89

**

MAR 12 2015

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

699

125268

599

125635

100

D3493-1

DAS

Manufactured

No

250

Each

107.0000 2 2

D3493-1

46

Washer

9-89

**

MAR 12 2015

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

97

125906

97

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

AN8C21A

Purchased

No

250

Each

47.0000 2 2

AN8C21A

DAS

Bolt

46
9-89

**

MAR 12 2015

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

45

m131100

18

m131247

20

m131250

7

M13K6S1

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Page 11

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

NO. 128618 MLS

1501-20

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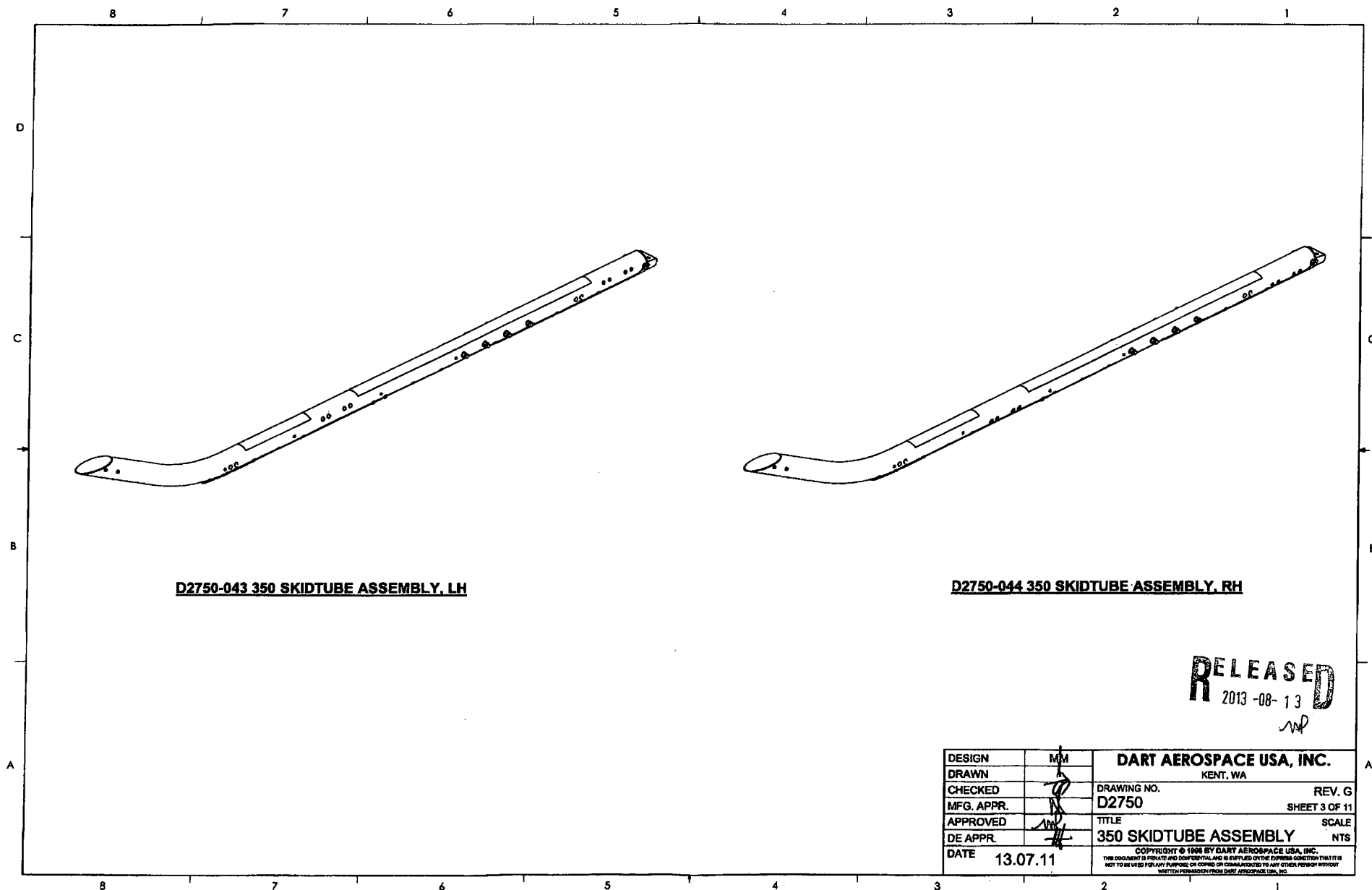
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5). ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6-7). UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 81339157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY

REV. G
SHEET 1 OF 11
SCALE
NTS

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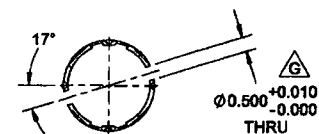
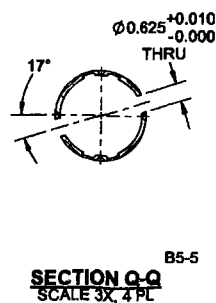
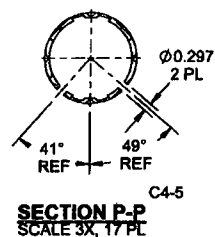
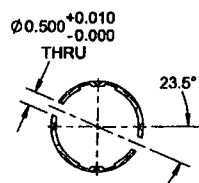
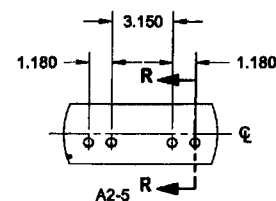
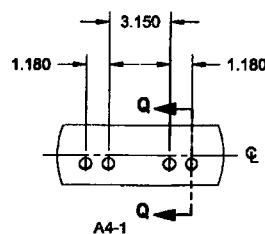
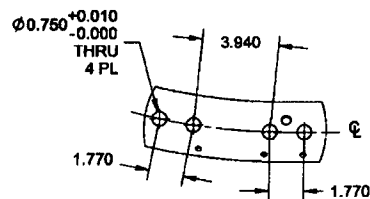
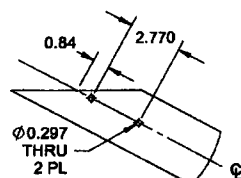
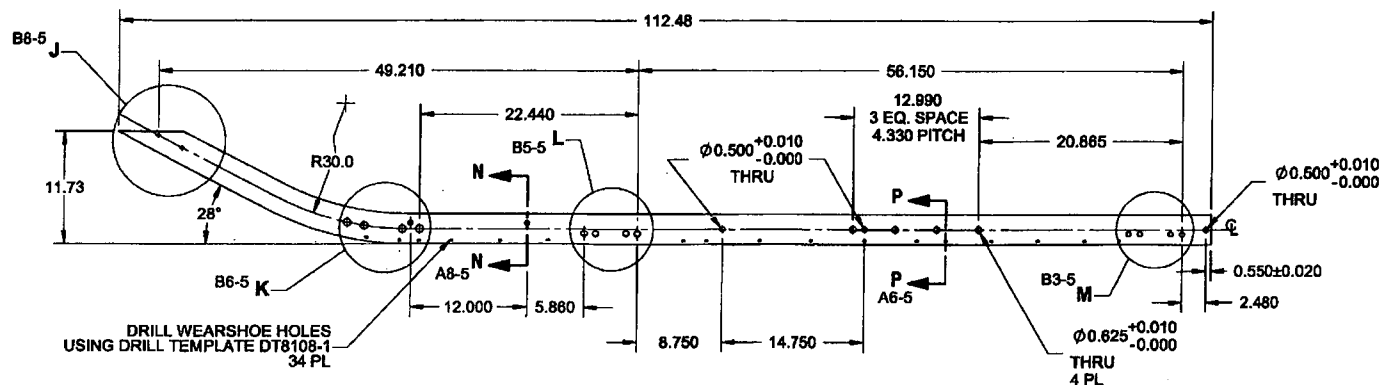


D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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wp

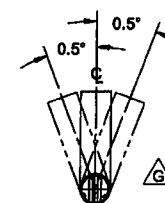
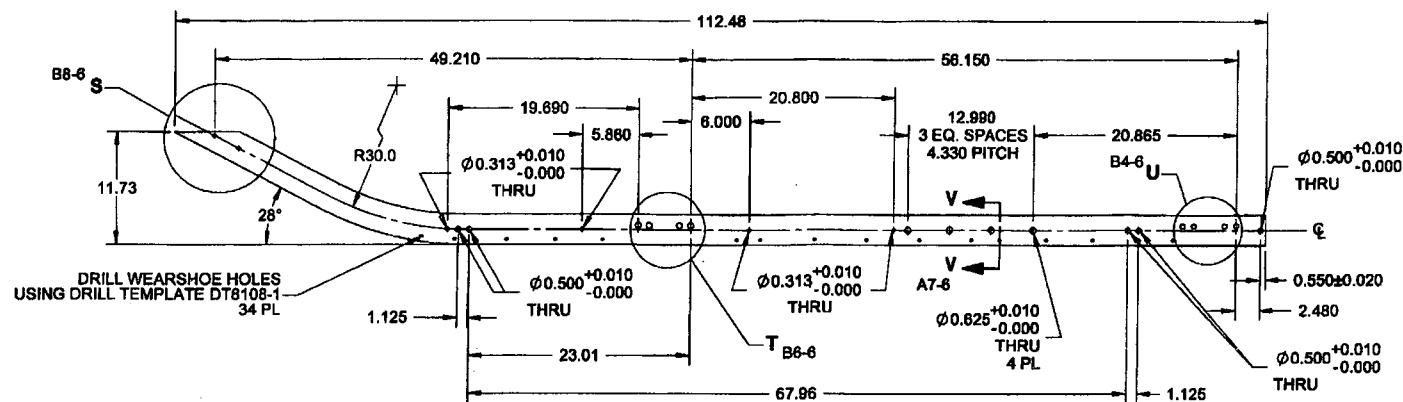
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MFG. APPR.		D2750	SHEET 3 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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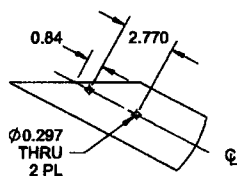
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8 7 6 5 4 3 2 1

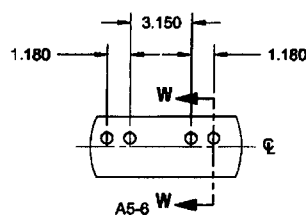


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

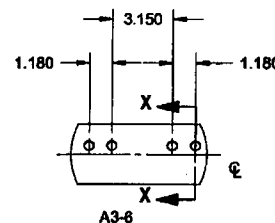
D2750-3 LH SKIDTUBE



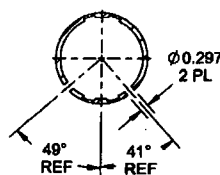
DETAIL S
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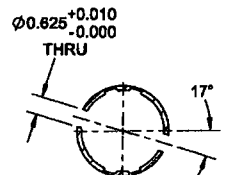
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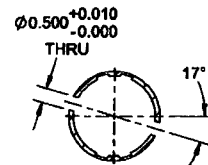
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

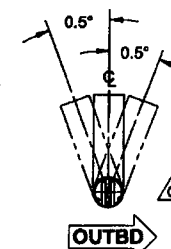
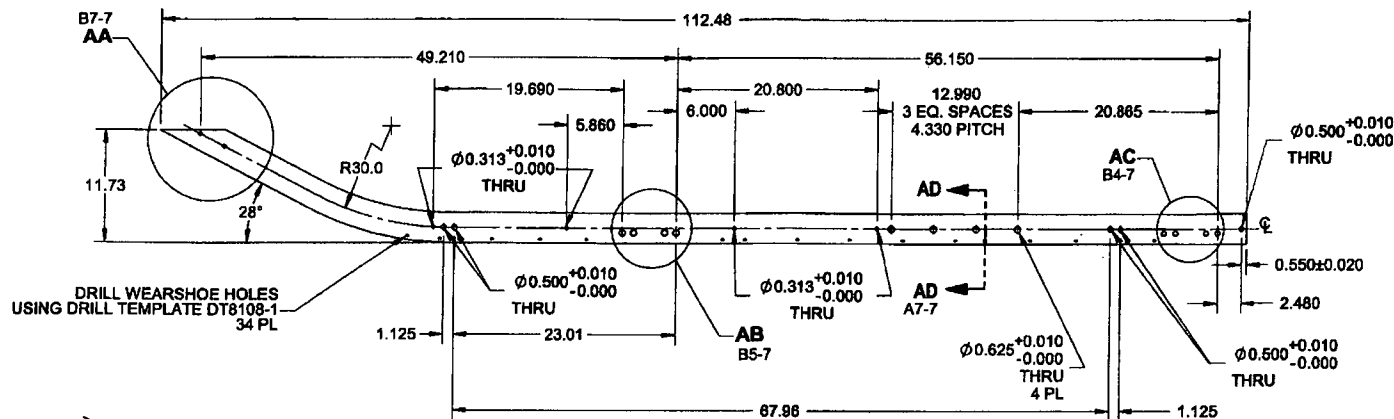


SECTION X-X
SCALE 3X, 4 PL

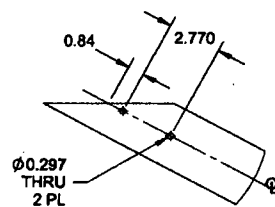
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MFG. APPR.		SHEET 6 OF 11	
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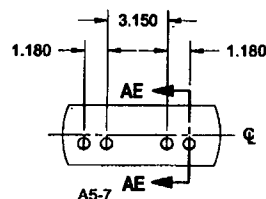
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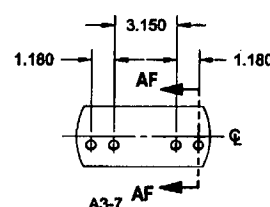
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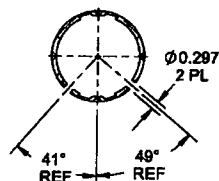
DETAIL AA
D7-7
SCALE 2X



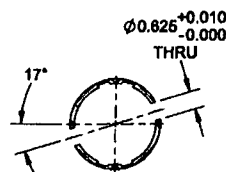
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C4-7
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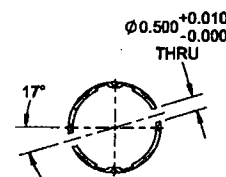
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL

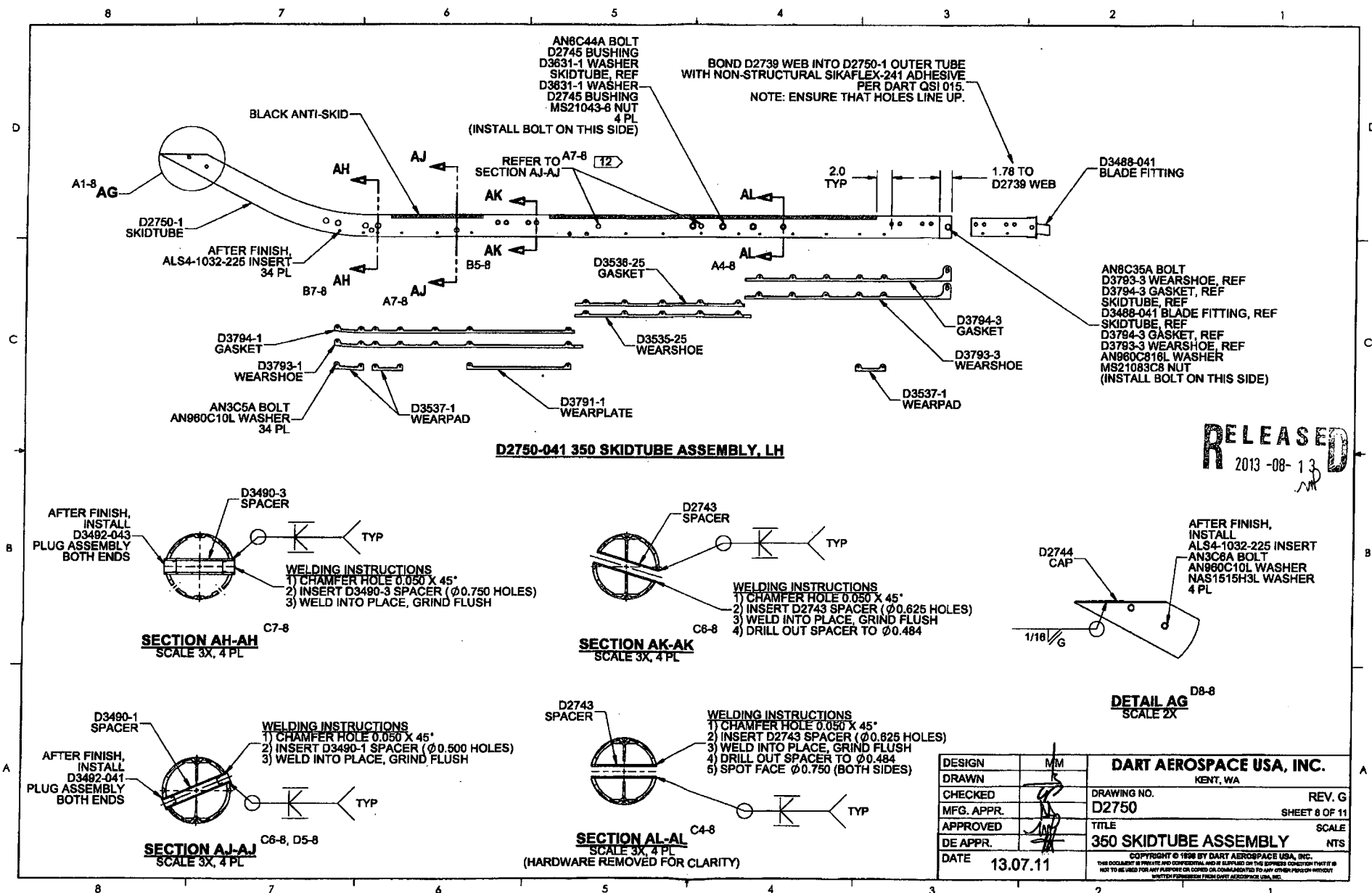


SECTION AF-AF
B4-7
SCALE 3X, 4 PL

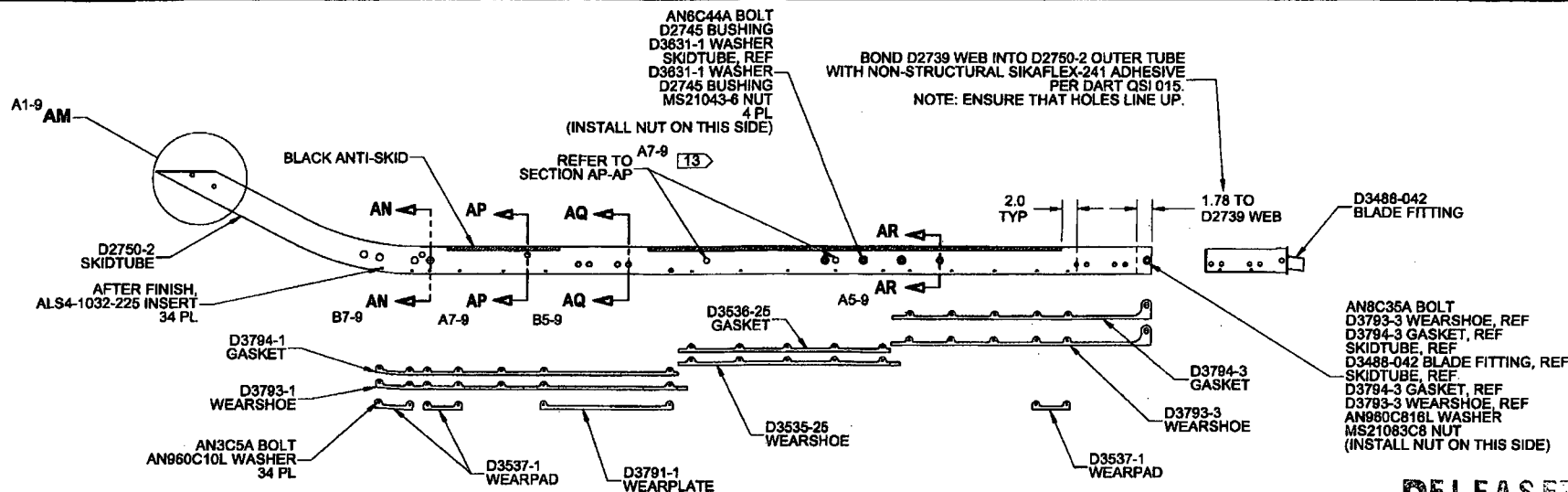
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MFG. APPR.		SHEET 7 OF 11	
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DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	

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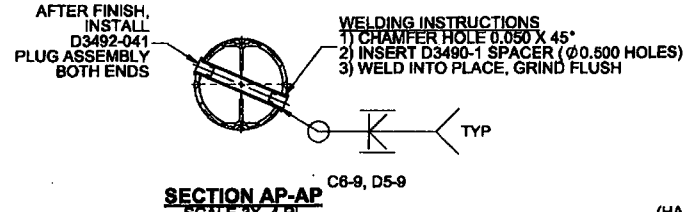
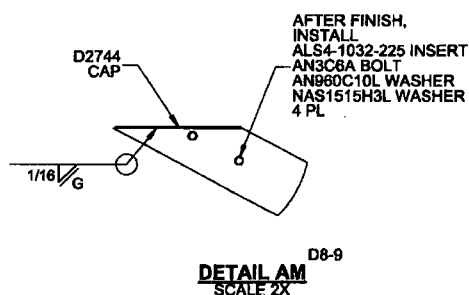
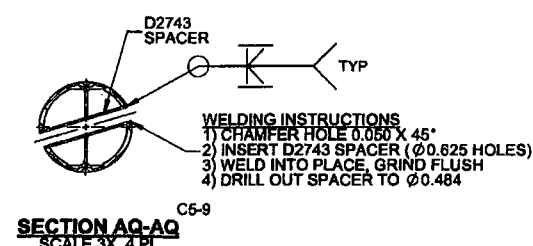
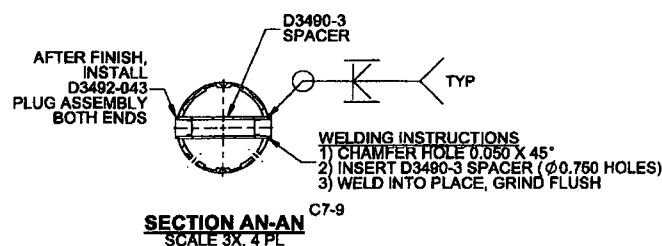


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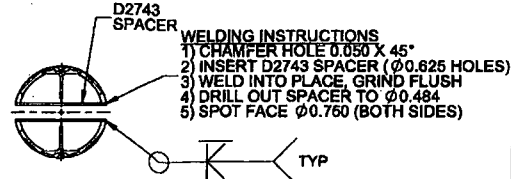


D2750-042 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13



SECTION AR-AR SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



DESIGN	MM	DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 9 OF 11
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